



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5489-3

Job Sheet 203021



Part No: D5489-3

Job Qty: 8 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/19

Job Tracking No:

Due Date: 12/16/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5489 REV.C3 IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS IPP REV:B 18.08.15 AS PER
DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

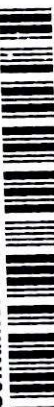
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		12/16/19	0.17	3.08	Waterjet - Flow		JRB 11/24/19
110	QC 2	8 pcs		12/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S234295



Part: D5489-3

Job No: 203021

Serial No/Batch: S234295

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/24/19

Plex 11/7/19 11:15 AM Dart.lajeunesse.marie

120 QC 8	8 pcs	12/16/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 11/24/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	NOV 25 2019 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	8 pcs	12/16/19	0.25 1.44	Small Fab - Brake - 1 - B4B	DAS 30 9-89 DEC 01 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	8 pcs	12/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DEC 02 2019 40 9-89
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 4-1-Assembly-B4B	8 pcs	12/16/19	0.00 0.39	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	RD 19-12-3

160 QC 3	8 pcs	12/16/19	0.00 0.00	Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
170 Packaging 3-1 - Stock - B4B	8 ✓ pcs	12/16/19	0.00 0.00	QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	WP001
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	

DEC 10 2019

Oscar

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 ✓ pcs	12/16/19	0.00 0.00	QC 21 - SA - 21 ✓	WP001
				QC 21 - SA - 70	DAS 21
				QC 21 - SA - 53	DEC 10 2019

Part Op **100** - 1-Cut as per Dwg (D5489-3) Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Assemble as per dwg) COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 5235921

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : FP002

180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	23.2000 sf (2.9 ea)	100-Waterjet - Flow - 1	5207058

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	23	275	0

Part Specifications
Specifications could not be found.

Plex 11/7/19 11:15 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

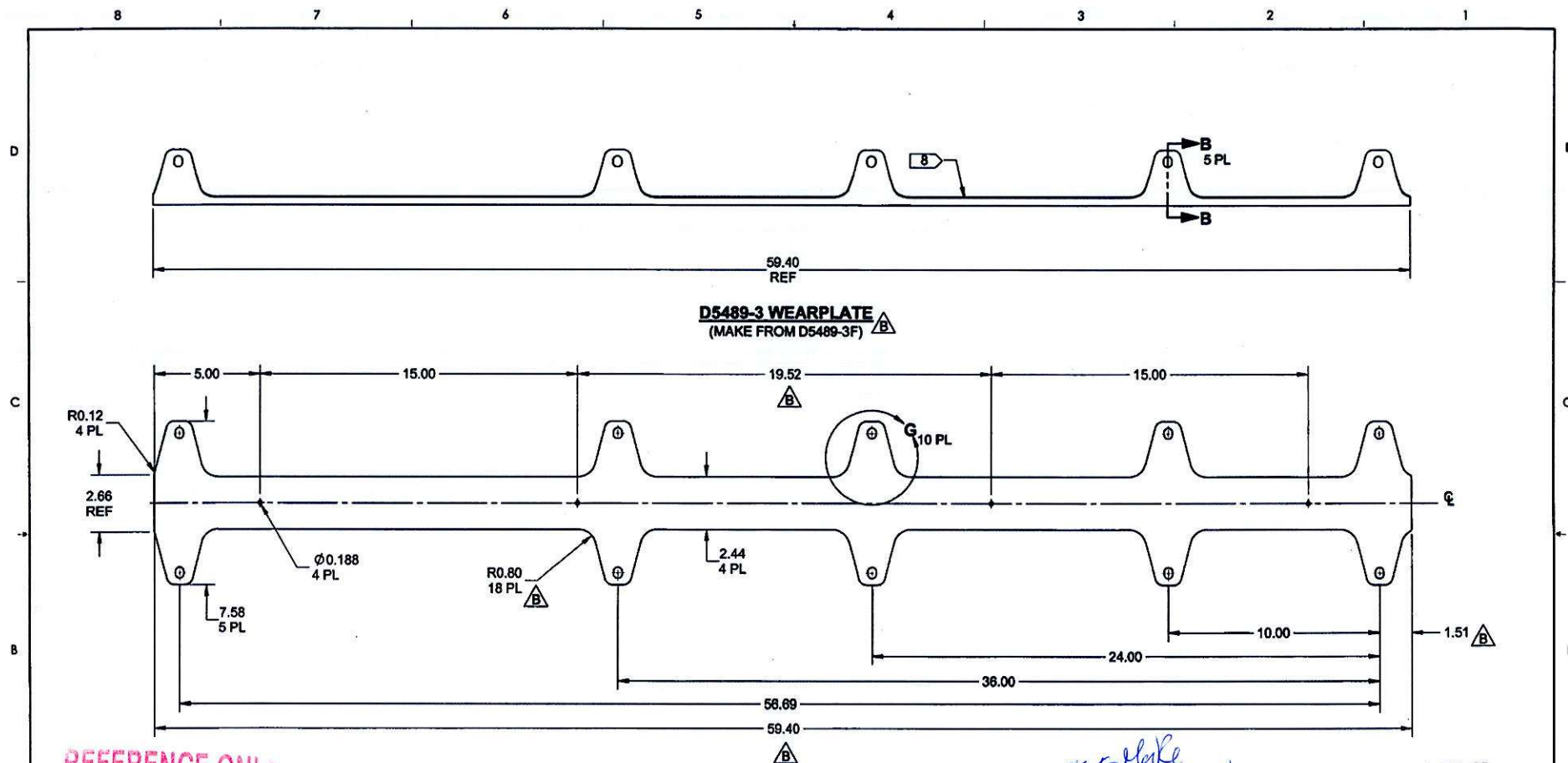


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



D5489-3 WEARPLATE
(MAKE FROM D5489-3F) (B)

D5489-3F WEARPLATE
(FLAT PATTERN) (B)

REFERENCE ONLY REFERENCE ONLY

OK to Make JAD 17/12/14
UNDER REVIEW
URF 19-1297/19.11.19 (SAD)

RELEASE
2018 AUG 16

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063"), PER MIL-S-5059 OR AMS 5513 (304), OR AMS 5524 (316), OR ASTM A240, OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI 044 6.1
 - 7) WEIGHT: 2.7 lbs
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

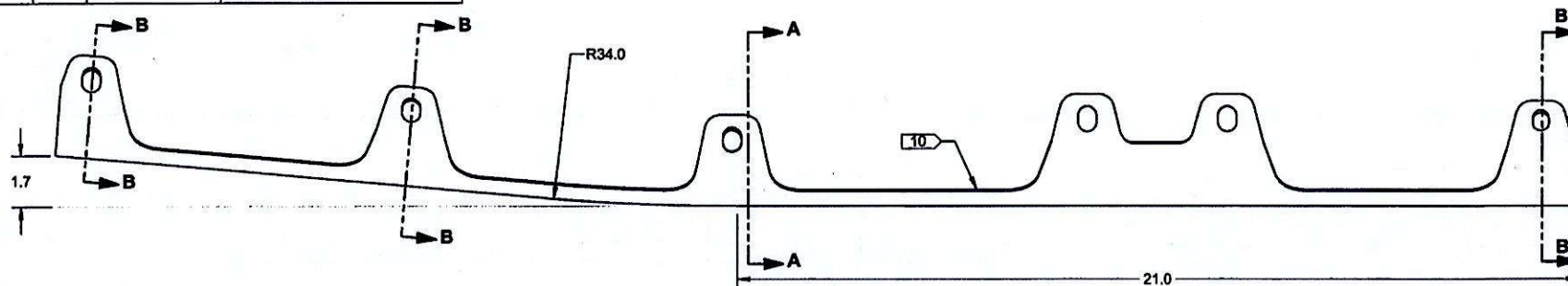
APPROVED

DESIGN	SAD	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	NO	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5489	SHEET 3 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	18.06.14	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

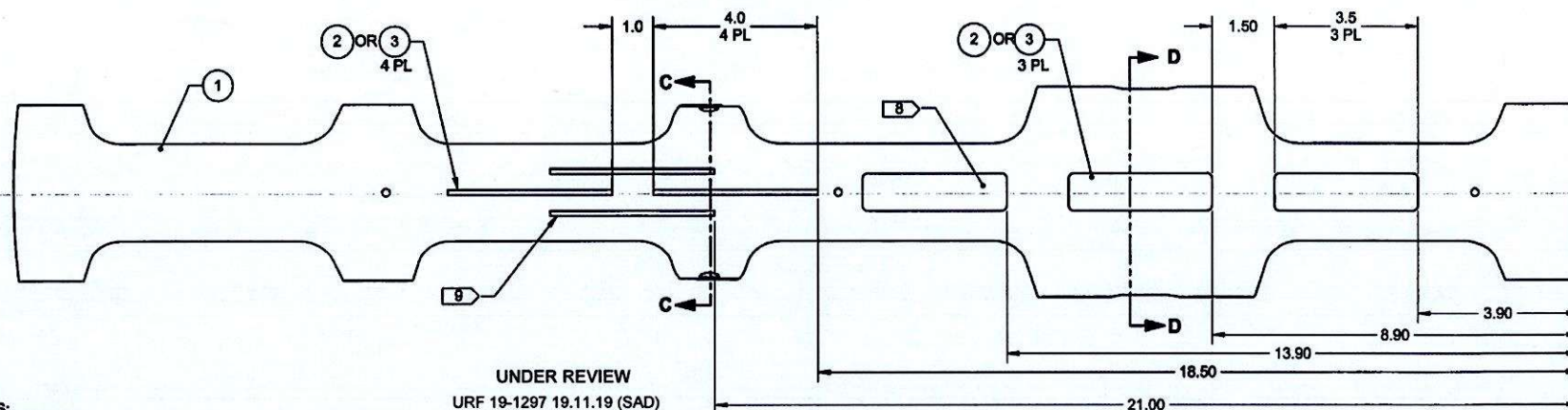
ITEM	QTY	P/N	DESCRIPTION
	X	D5489-045	WEARPLATE ASSEMBLY
1	1	D5489-5	WEARPLATE
2	A/R	8259	HARDCOAT SURFACING AUTOMATED WELDING
3	A/R	2059B	HARDCOAT SURFACING MANUAL WELDING

RELEASE

2018 AUG 16



D5489-5 WEARPLATE
(MAKE FROM D5489-5F) Δ



UNDER REVIEW
URF 19-1297 19.11.19 (SAD)

D5489-045 WEARPLATE ASSEMBLY Δ

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 2.9 lbs
- 8) WELDING: BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) WELDING: BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

SAD
SAD
NO
JFS
NO
DS-4

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D5489
TITLE
WEARPLATE
REV. B
SHEET 4 OF 7
SCALE
NTS

18.06.14

COPYRIGHT © 2017 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

